

# Work Order ID 83855

**\*83855\***

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April-26-12 2:25:39 PM

Item ID: D3067-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: End Plate  
 Start Date: 26/04/2012 Start Qty: 60.00 **\*60\*** Cust Item ID:  
 Required Date: 10/05/2012 Req'd Qty: 60.00 **\*60\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/26 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool # , Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3067	Rev A

100		0.00						
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**\*100\*** FLOW WATER JET 60 0 Jm/SL  
 Waterjet Memo 0.00 12-5-12  
 FLOW CNC Waterjet 1-Cut as per Dwg D3067  
 5052 063 Dwg Rev: A  
 Prog Rev: A  
 2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00						
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**\*110\*** QC Memo 0.00 60 0 Jm/SL  
 Quality Control 12-5-12

120	QC8- Inspect parts - second check	0.00						
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**\*120\*** QC Memo 0.00 57/3/14 60 0 10/5/14  
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Packaging

\*\*\* STOCK IN STEP CELL\*\*\*

60 SB  
pls/ce

counts  
x60

60  $\phi$  14  
12.05.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 83855****\*83855\***

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Item ID: D3067-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: End Plate

Start Date: 26/04/2012 Start Qty: 60.00

**\*60\***

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 60.00

**\*60\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

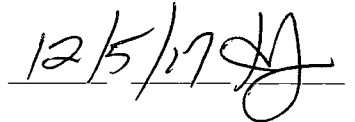
**\*160\***

QC

Memo

0.00

Quality Control



MF 12-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 83855

\*83855\*

Parent Item: D3067-1

\*D3067-1\*

Parent Item Name: End Plate

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP: 03.01.21 Remove step 6 (Deburr) KJ

IPP Rev:B Now on Water jet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased			No	100	sf	67.8526	0.0625	3.947368			

\*M5052H32S 063\*

5052-H32 .063 Sheet

\*\*

Location

Loc Qty

Loc Code

MAT022

67.852632

114322

12.852632

120603

55

120603

Jm/sd  
12-5-12

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

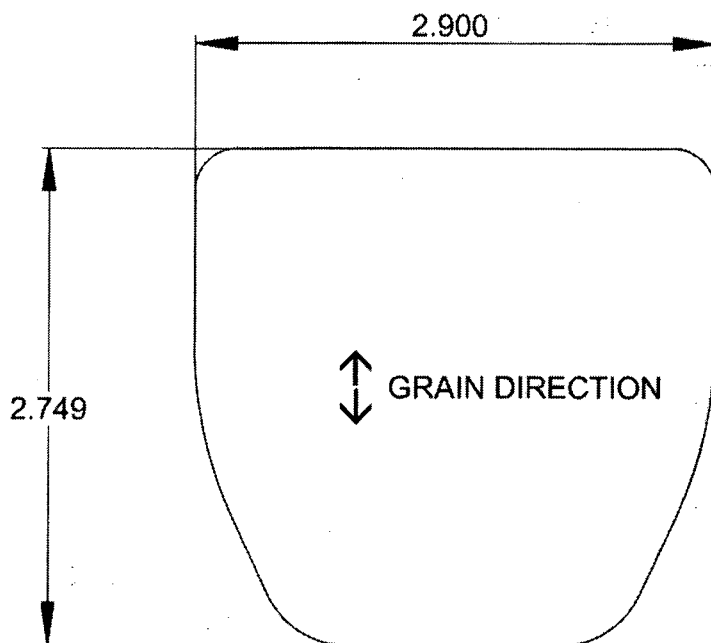
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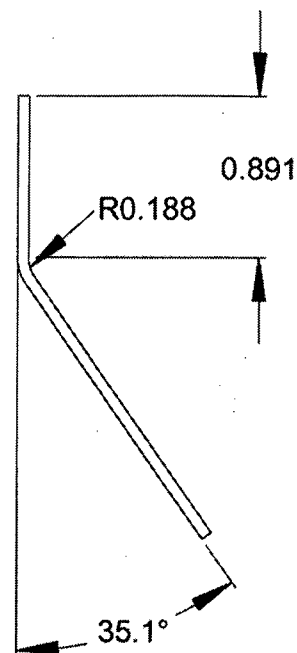


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3067</b>	REV. A SHEET 1 OF 1
DATE <b>02.09.11</b>		TITLE <b>END PLATE</b>	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED  
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

12/04/20  
NO. 03855 MCT  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)  
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)  
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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